

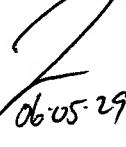
Date: Monday, 5/1/2006 4:22:48 PM  
User: Kim Johnston

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING ANGLE	
Job Number	: 26908				
Estimate Number	: 10415				
P.O. Number	: N/A		Part Number	: D2417	
This Issue	: 5/1/2006	S.O. No. : N/A	Drawing Number	: D2417 REV. B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: N/A		Material	: N/A	
Written By	: <u>Sign comment Below</u>		Due Date	: 6/30/2006	
Checked & Approved By	: <u>gj 06.05.02</u>		Qty:	2 Um: Each	
Comment	: Est:C 03-04-14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF				
<b>Additional Product</b>					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M2024T3S063	2024-T3 .063 sheet			
		 <b>Comment:</b> Qty.: 0.0411 sf(s)/Unit Total : 0.0821 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: <u>M19059</u> Identify for D2417			
2.0	SHEAR	 <b>Comment:</b> SHEAR Cut blank: 3.300" x 1.550" Grain along 1.550"			
3.0	HAAS1	 <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 <i>Water Jet</i> Machine as per Folio FA328 and Dwg.D2417 Stack of 7 Identify as D2417			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	 <b>Comment:</b> SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No DQA:  Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-25	4	Oval in wrong direction. <del>Excessive</del> 2 parts scrap.	 	Ensure employee checks the grain direction on the Oval. Scrap & destroy and replace parts.	SAD 06/05/26	 06-05-25	 	 06-05-25
06-05-29	3	.128 holes oversized a little by .009, from water jet cutting over the cross ribs.	 	Holes are acceptable and will assemble well.	N/A 06-05-29	 06-05-29	 	 06-05-29

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:22:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 26908

Part Number: D2417

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

EN 06/05/02 ②

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

SB 06/06/02 ②

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Open D2417 mounting angle hole to 00.437" as per Dwg D2417.

2- Deburr hole

NA JH/06/01

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 06/06/02

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06/06/02 ②

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PC 06/06/02 ②

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STG

PC 06/06/02 ②

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/06/02 ②

Job Completion



06/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

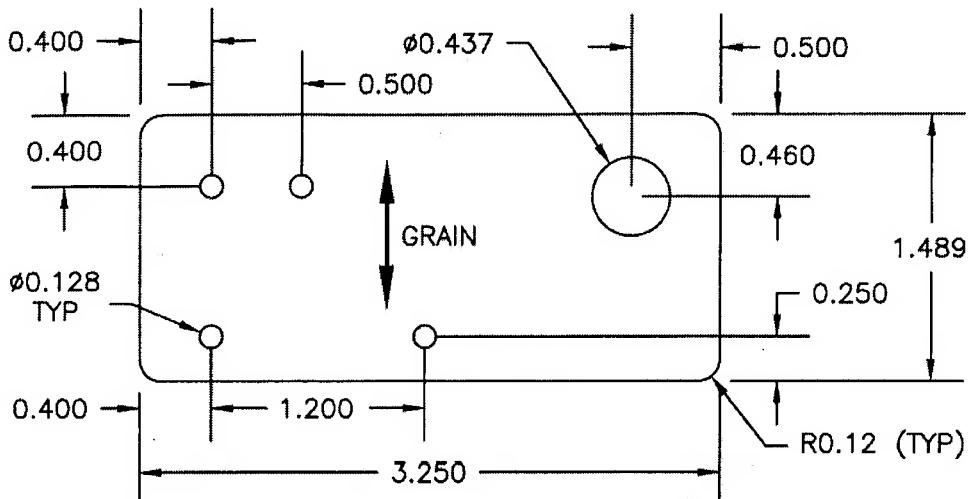
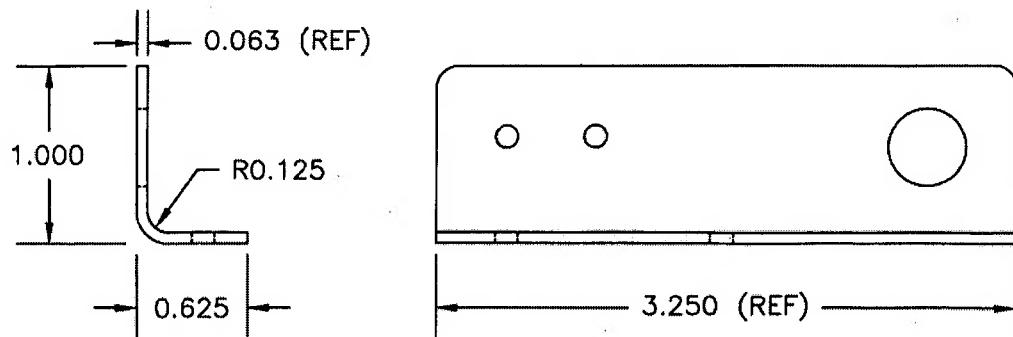
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY  
SEND

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2417 REV. B SHEET 1 OF 1
DATE 03.04.09		TITLE MOUNTING ANGLE SCALE 1:1
A	95.04.06	NEW ISSUE
B	03.04.09	ADDED $\phi 0.128$ & FLAT PATTERN

RELEASED  
03.05.07 *H***FLAT PATTERN****BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC COM 2024-T3S.063)
- 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
- 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *26908*

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DART AEROSPACE LTD	Work Order:	26908
Description: M16 ANGLE	Part Number:	D2417
Inspection Dwg: 2417 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.250	$\pm 0.010$	3.256	✓		Vern	
1.200	$\pm 0.010$	1.194	✓		Vern	
1.489	$\pm 0.010$	1.491	✓		Vern	
0.250	$\pm 0.010$	0.251	✓		Vern	
0.460	$\pm 0.010$	0.460	✓		Vern	
0.500	$\pm 0.010$	0.502	✓		Vern	
0.500	$\pm 0.010$	0.502	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
$\phi 0.128$	$+0.005/-0.001$	$\phi 0.128$	✓		Vern	
R0.12	$\pm 0.016$	R0.12	✓		Radius gauge	
$\phi 0.437$	<del><math>\phi 0.437</math></del> $+0.006/-0.001$	$\phi 0.438$	✓		Vern	

Measured by:	SAD/PY	Audited by:	EP	Prototype Approval:	
Date:	06/05/24	Date:	06/05/24	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	